

Date: Monday, 07/04/2008 2:29:12 PM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : LUG
Job Number : 38441	
Estimate Number : 10008	
P.O. Number :	Part Number : D2591
This Issue : 07/04/2008 S.O. No. :	Drawing Number : D2591 REV D
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : D
Previous Run : 37857	Material :
Written By :	Due Date : 24/04/2008 Qty: <u>50</u> Um: Each
Checked & Approved By : <u>JO 08.4.06</u>	
Comment : Est Rev:l Removed from 9 Digit 05-10-25 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M1010B0750X02500	ASTM A21 Steel .75"x2.5"
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Comment: Qty.: 0.2340 f(s)/Unit Total : 5.6160 f(s)
 ASTM A36 Steel bar 2.50" x 0.75" thick(M1010-B0.750X02.500)
 Batch: 1107513

ml 08/04/08

50
24

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
 Cut blanks: 2.700" long

ml 08/04/08

50
24

3.0	HAAS <i>Purchasing</i>	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 1- Machine as per Folio FA 039 and Dwg D2591 *issue P10 for meter*
asper dwg D2591 REV.D.
 2-Deburr if required

P10 6097

4.0	Q02	INSPECT PARTS AS THEY COME OFF MACHINE
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PK



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Rec'd + inspect for transit damage

08/04/08 50

5.0	Q06	SECOND CHECK
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Comment: SECOND CHECK

08/04/25 50 *correct*

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Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PAT Duval

AS 08/04/25 @SS

7.0

QC21

FINAL INSPECTION/W/O RELEASE



08/04/28 JF

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

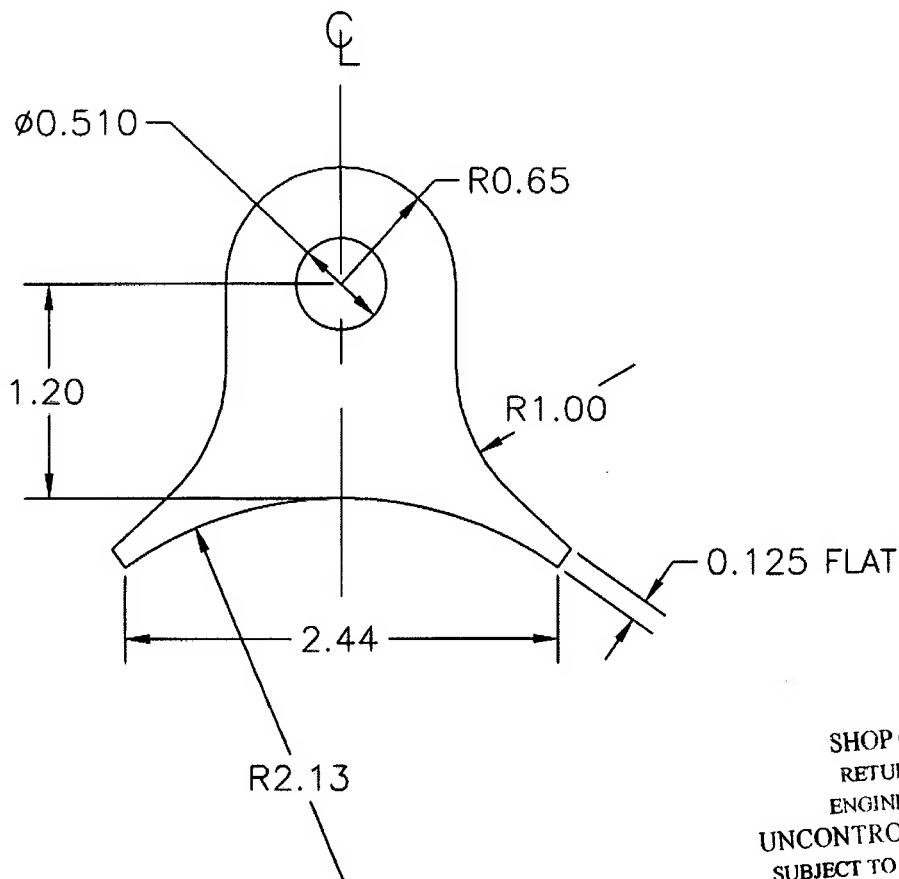


MF 08-04-25



DESIGN <i>MEY</i>	DRAWN BY <i>MEY</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>KE</i>	APPROVED <i>BW</i>	DRAWING NO. D2591	REV. D SHEET 1 OF 1
DATE 98.01.21		TITLE GHW LUG	SCALE 1:1
A	96:09:16	NEW ISSUE	
B	97:06:17	RE-DESIGN TO FLAT BOTTOM	
C	97.12.12	RE-DESIGN TO RADIUS BOTTOM	
D	98.01.21	0.125 FLAT WAS 0.067 FLAT	

RELEASED
98.01.21 DS



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 3899

BREAK ALL SHARP CORNERS 0.010 TO 0.020
MATERIAL: ASTM A36 STEEL 0.50 THICK
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
PART IS SYMMETRIC ABOUT CENTER-LINE
ALL DIMENSIONS ARE IN INCHES



CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

QUANTITY

PART NUMBER

PART NAME

P.O. NUMBER

50

D2591

Lug in Steel

6097

MATERIAL: supplied by DART M1010B0750X02500 M107513

200

D2230-3

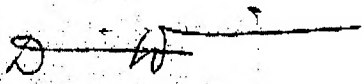
Mounting Lug

6097

MATERIAL: supplied by DART D2423 B33310

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


Denise Robinson

Vankleek Hill, April 24, 2008